

Work Order ID 59762

Thursday, June 10, 2010 2:45:09 PM

Page 1

Item ID: D130-780-011

Accept

Revision ID:

Item Name: Aft LH Door Hinge

Start Date: 6/10/2010 Start Qty: 2.00

Required Date: 6/25/2010 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan: *P* Date: 10-6-10Tooling: Date: QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI 9502

A

IIN-D130-780

B

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D130-780-011
CHG 003*5/10/06/30**HJ for BG 10/06/30*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-6-30 (2x) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59762

Thursday, June 10, 2010 2:45:09 PM



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Item ID: D130-780-011

Accept



Setup Start

Revision ID:

Item Name: Aft LH Door Hinge

Stop



Start Date: 6/10/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
130		0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D130-780-011								
	Location: <u>10</u>								
	PPP rev: <u>C</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

8/10/06/10

2

10-6 305f (2x)

10/07/01 10/7/11

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Picklist Print

Thursday, June 10, 2010 2:45:13 PM

Page 1

Work Order ID: 59762

Parent Item: D130-780-011

Parent Item Name: Aft LH Door Hinge

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D130-780-015		Manufactured	No			110	Each	4.0000	1	2			



Closeout Installation

CHG001



10-6-30

Location

Loc Qty

Loc Code

FG

4

56838

4

D3552-13

Manufactured

No

110

Each

7.0000

1

2

2

10-6-30

Location

Loc Qty

Loc Code

ST272A

7

56392

7

D3892-1

Manufactured

No

110

Each

97.0000

1

2

2

10-6-30

Location

Loc Qty

Loc Code

ST416

97

47330

97

cut to 5"

D3813-041

Manufactured

No

110

Each

4.0000

1

1/2

10-6-30

Location

Loc Qty

Loc Code

ST090

4

53043

4

2

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D3813-043 Hinge Assembly, Lower Door		Manufactured	No			110	Each	2.0000	1	2			

Location	Loc Qty	Loc Code
ST090	2	

D3814-1 Hinge, Upper Airframe		Manufactured	No	53044		110	Each	8.0000	1	2			
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Location	Loc Qty	Loc Code
ST091	8	
50119	2	
50261	6	

D3814-3 Hinge, Lower Airframe		Manufactured	No			110	Each	14.0000	1	2			
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Location	Loc Qty	Loc Code
ST091	14	
50120	2	
50475	12	

D3816-1 Spacer		Manufactured	No			110	Each	12.0000	2	4			
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Location	Loc Qty	Loc Code
ST091	12	
45675	12	

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Page 2

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D3816-3

Manufactured

No

110

Each

8.0000

4

8

Qty Issued

Date Issued

Status



Spacer

Location

Loc Qty

Loc Code

ST091

8

52930

8

D3817-041

Manufactured

No

110

Each

17.0000

1

2



Anchor Nut Plate

Location

Loc Qty

Loc Code

ST092

17

50381

17

AN3-5A

Purchased

No

110

Each

817.0000

2

4



Bolt

Location

Loc Qty

Loc Code

ST350

817

105057

817

AN3-7A

Purchased

No

110

Each

133.0000

3

6



Bolt

Location

Loc Qty

Loc Code

ST351

133

113539

14

114227

19

114784

100

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AN310-4
NUT

Location Loc Qty Loc Code

ST324 26
114716 26

ST349 3
114341 3

Purchased No 110 Each 50.0000

Location Loc Qty Loc Code

ST359 50
113121 20
113288 30

Purchased No 110 Each 97.0000

AN970-4
Washer

Location Loc Qty Loc Code

ST349 97
112991 97

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Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			110	Each	3,282.000	5	10			
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Location	Loc Qty	Loc Code
ST300	3282	
113537	18	
113644	3	
114523	761	
114718	500	
114784	2000	

MS24665-2-12

Purchased

No

110

Each

111.0000

2

4



COTTER PIN

Location	Loc Qty	Loc Code
ST309	111	
111499	111	
110	Each	76.0000

MS24694-S46

Purchased

No

110

Each

76.0000

3

6



SCREW

Location	Loc Qty	Loc Code
ST289	76	
111499	76	

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Page 6

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149D0363J		Purchased	No			110	Each	785.0000	8	16			
													
Washer													

Location	Loc Qty	Loc Code
ST298	785	
113288	2	
114292	183	
114884	600	

NAS1149D0463J	Purchased	No				110	Each	1,256.000	2	4			
													
Washer													

Location	Loc Qty	Loc Code
ST298	1256	
114576	756	
114883	500	

D3622-1	Manufactured	No				110	Each	13.0000	2	4			
													
Ball Stud													

Location	Loc Qty	Loc Code
ST074	13	
55199	13	

D3820-1	Manufactured	No				110	Each	20.0000	1	2			
													
Bracket													

Location	Loc Qty	Loc Code
ST092	20	
42079	1	
45732	19	

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W/O:		WORK ORDER CHANGES					
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Page 7

Work Order ID: 59762

Parent Item: D130-780-011

Parent Item Name: Aft LH Door Hinge

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC





















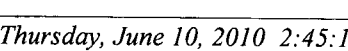


IPP Rev:B as

Start Date: 6/10/2010

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042L5		Purchased	No			110	Each	726.0000	2	4			
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5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X							D130-780-041	SPACEPOD™ LH, EC 130 B4
	X						D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X					D130-780-043	DOOR ASSEMBLY, LH
	1		X				D130-780-044	DOOR ASSEMBLY, RH
1				X			D130-780-011	LH SLIDING DOOR HINGE KIT
1	1				X		D130-780-013	SWITCH RELOCATION KIT
						X	D130-780-015	CLOSEOUT KIT
2	2						D3815-041	WEB ASSEMBLY
3	3						D3815-5	PACKER
		1	1				D2589	KEYS, KEY CHAIN
1	1						D3837-1	DECAL
1	1						D3015-3	LOCK NUT
		1					D3186-3	SPACEPOD™ DOOR, LH
			1				D3186-4	SPACEPOD™ DOOR, RH
1							D3798-041	FLOOR
	1						D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
	1						D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
1	1						D3550-1	STRUT
		1	1				D3552-7	GAS SPRING
1	1						D3554-7	BALL STUD
4	4						AN3-3A	BOLT
4	4						AN3-6A	BOLT
2	2						AN3-10A	BOLT
1	1						AN5-5A	BOLT
38	38						AN525-10R7	SCREW
8	8						AN526C832R14	SCREW
6	6						MS24694S54	SCREW
7	7						MS24694S67	SCREW
1	1						MS24694S69	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J	WASHER
		4	4				NAS1149DN832J	WASHER
3	3						NAS1149D0563J	WASHER
		2	2				NAS1515H3	NYLON WASHER
		2	2				MS21042L08	NUT
22	22						MS21042L3	NUT (or MS21042-3)
1	1						MS21042L5	NUT
10	10						AKS7-1032-130	INSERT
28**	28**						AKS7-1032-130	INSERT
10	10						MS21059L3	NUTPLATE

REFERENCE ONLY

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Revision: B

Date: 09.06.11

W/O:			WORK ORDER CHANGES					
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-041	-042	-043	-044	-011	-013	-015	Part Number	Description
					2		D3819-1	MALE SPADE CONNECTOR
					2		D3597-1	FEMALE SPADE CONNECTOR
					1		D3598-2-096	EXPANDABLE SLEEVE
					24		D3599-1	TIE-WRAP
					24		D3600-1	TIE-WRAP MOUNT
					24 FT		M22759/41-22-9	WIRE
		1*	1*				D2464-1250	NEOPRENE SEAL
1**		1*					D3837-3	DECAL
	1**		1*				D3837-4	DECAL
		2*	2*				D2586	LATCH
		2*	2*				D2585	MOUNTING CHANNEL
		2*	2*				D2621	LATCH PLATE
		2*	2*				MS27039-1-15	SCREW
		2*	2*				NAS1149D0363J	WASHER
		2*	2*				MS21042L3	NUT (or MS21042-3)
		1*	1*				D2857-1	HINGE BRACKET
		1*	1*				D2857-2	HINGE BRACKET
		2*	2*				D2228	BACKING PLATE
		8*	8*				AN526C832R10	SCREW
		8*	8*				NAS1149DN832J	WASHER
		8*	8*				MS21042L08	NUT
		1*	1*				D3557-1	BRACKET
		2*	2*				D2228	BACKING PLATE
		1*	1*				D3554-7	BALL STUD
		1*	1*				NAS1149D0563J	WASHER
		1*	1*				D3015-3	LOCK NUT
		2*	2*				AN526C832R14	SCREW
		2*	2*				AN526C832R10	SCREW
		4*	4*				NAS1149DN832J	WASHER
		4*	4*				MS21042L08	NUT
2**	2**						D2237	STRIKER PLATE
4**	4**						MS20426AD4-5	RIVET
2**	2**						D3538-1	HINGE BRACKET
2**	2**						D2179	HINGE BRACKET PLATE
4**	4**						AN526C832R24	SCREW
4**	4**						NAS1149DN832J	WASHER
4**	4**						MS21042L08	NUT
				1			D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1			D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***			D3518-3	ROD END

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

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-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2***			NAS509-6	NUT
				1			D3814-1	HINGE, UPPER AIRFRAME
				1			D3814-3	HINGE, LOWER AIRFRAME
				2			D3816-1	SPACER
				4			D3816-3	SPACER
				1			D3817-041	ANCHOR PLATE
				2			AN3-5A	BOLT
				3			AN3-7A	BOLT
				2			AN310-4	CASTLE NUT
				2			AN4-17	BOLT
				2			AN970-4	WASHER
				5			MS21042L3	NUT
				2			MS24665-212	COTTER PIN
				3			MS24694S46	SCREW
				8			NAS1149D0363J	WASHER
				2			NAS1149D0463J	WASHER
				1			D3552-7	GAS SPRING
				2			D3622-1	BALL STUD
				1			D3820-1	DOOR SUPPORT
				2			MS21042L5	NUT
				2			NAS1149D0563J	WASHER
				1			D3892-1	SEAL
						1	D3983-1	OUTER CLOSEOUT
						1	D3983-3	INNER CLOSEOUT
						1	D3983-5	HINGE CLOSEOUT
						1	D3983-047	CLOSEOUT ATTACHMENT
						1	D3983-9	SPACER
						2	AN525-10R6	SCREW
						1	AN525-10R24	SCREW
						1	NAS1149D0363J	WASHER
						1	MS21042L3	NUT

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

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Revision: B

Date: 09.06.11

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries